

Date: Monday, 22/09/2008 1:15:23 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKID RH 206L1,L3,L4&407
Job Number :	42168		
Estimate Number :	10328		
P.O. Number :		Part Number :	D206642512
This Issue :	22/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	/ /	Project Number :	N/A
Previous Run :	42166	Drawing Revision :	L
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.9.28</u>	Due Date :	06/10/2008
Comment :	Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM est rev D 07.06.06 added K642-512 EC Est Rev:E 07-12-05 ECN 1080p Rev L DD verified by:		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.10.01



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-512 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	42168A	FLOAT SKIDTUBE ASSEMBLY
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Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

1 x D206-642-541 Batch 42168A

SQ

4.0	K642 512	saddle kit 642-511
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37361



(15)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

saddle kit 642-512

8/10/06

SU

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

08.10.16
 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 1:18:31 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE ASSEMBLY
Job Number	: 42168A		
Estimate Number	: 10309		
P.O. Number	:	Part Number	: D206642541
This Issue	: 22/09/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3274 REV D
First Issue	: / /	Project Number	: N/A
Previous Run	: 42166A	Drawing Revision	: D
Written By	:	Material	:
Checked & Approved By	: <u>1008.9.22</u>	Due Date	: 06/10/2008
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM Est Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD Est Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC Est Rev:F 08-06-02 add comment DD verified by:EC		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D206-642-541 CHG003 <i>N/A</i>		
2.0	D26001190	Extrusion Round 3" 206
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-1-190 3" OD Tube <u>31032</u> <i>RT 08-09-23</i>		
3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274 <i>RT 08-09-23</i> 2- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 3-Drill #40 Aft cap pilot hole using DT8025 4-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274 <i>RT 08-09-24</i> 5-Remove inner indexing ridge on fwd and aft end of skidtube as per Dwg D3274 6-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end. <i>28-9-27</i>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 1:18:32 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42168A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

B 35210

(12)

M 8-10-3

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

M 109213

8E 08-10-06

3-Grind cross bolt welds flush as per Dwg D3274.

M 8-10-6

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

M 8-10-6

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/06

(10)

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/06

(10)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-1

08/10/06

(1X)

19.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45
320 OF
8:15

M-1
08/10/07

(1X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 1:18:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42168A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 1110792

Sikaflex expire date: 08/10

ll

08-10-08

(X1)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/08 (X1)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location:

ll

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/17

Job Completion



MF 08-10-16

B42168A

206

NO. 176

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barelay Elliott
Job number: 41952A
Part number: D206 642241
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]



TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

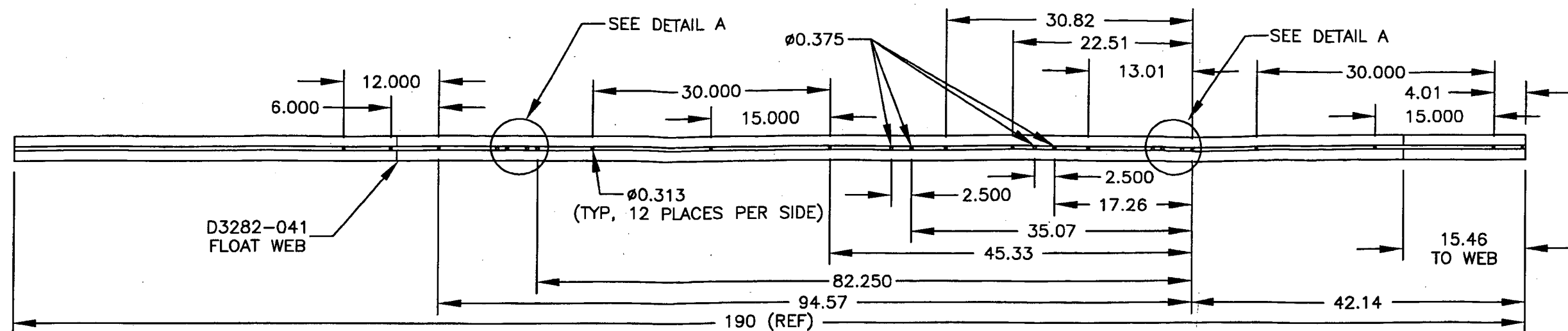
Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

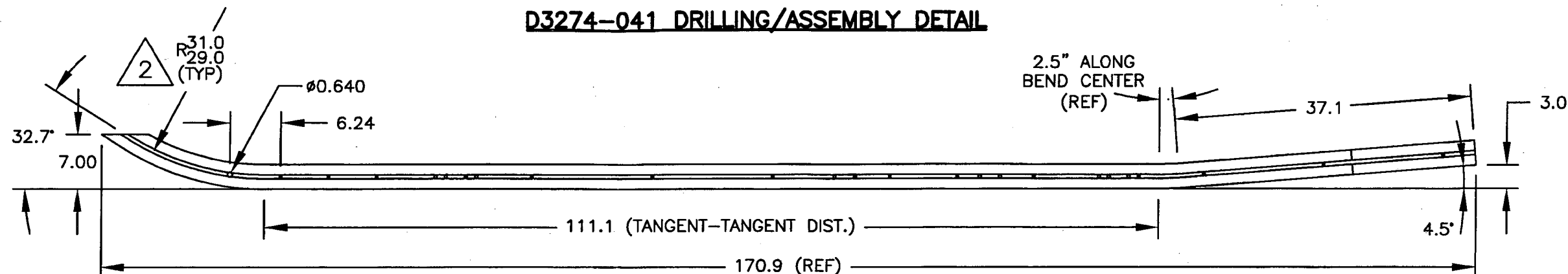
Qualifier Pet. Duval Date of Test Coupon 08-09-26

Welder Barelay Elliott Date of Test Coupon 08-09-26

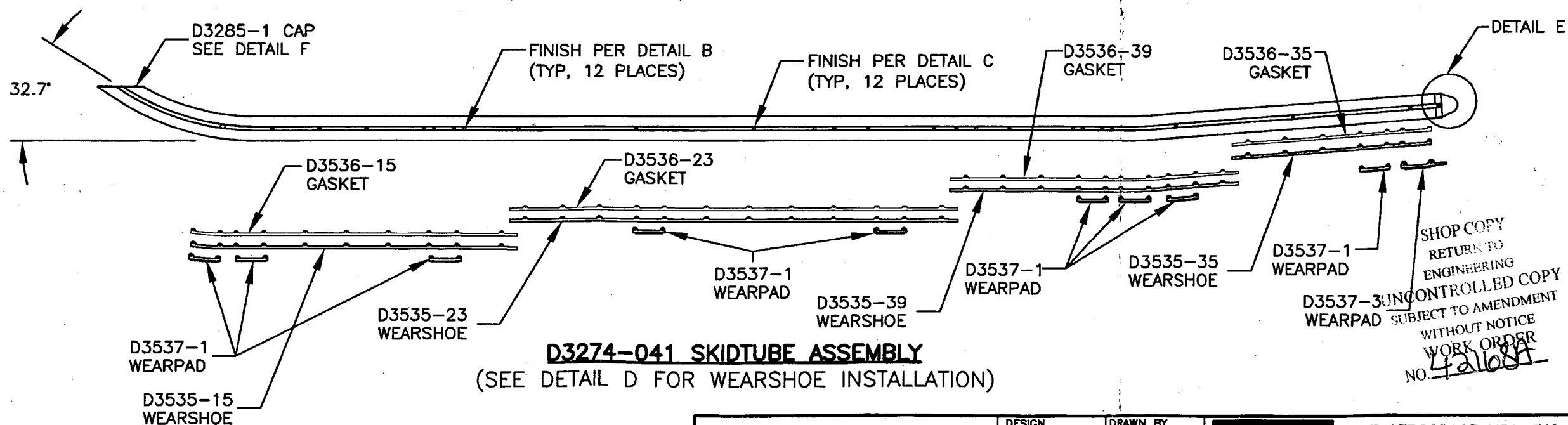
The above named individual is qualified in accordance with AWS D17.1.2001 to weld



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

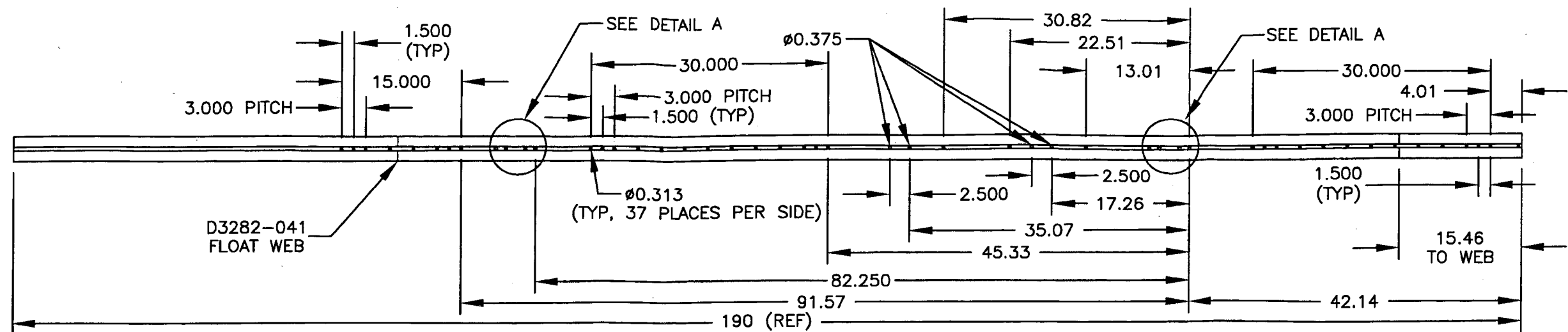
RELEASED

07.02.12

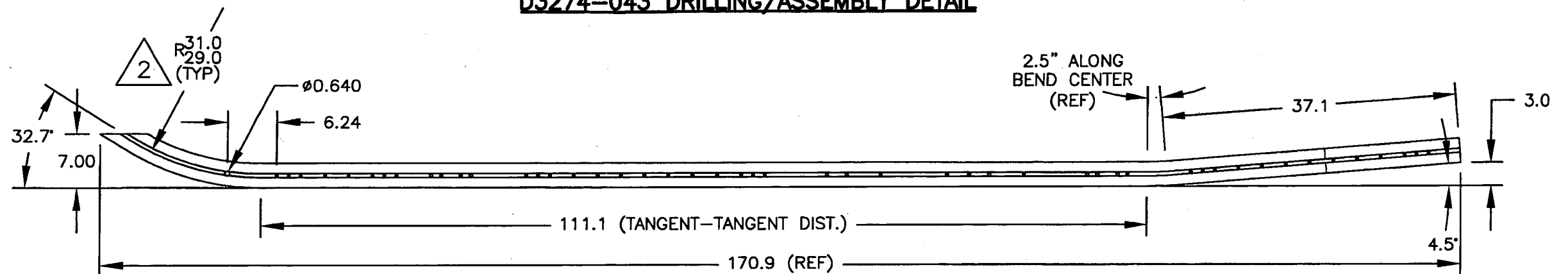
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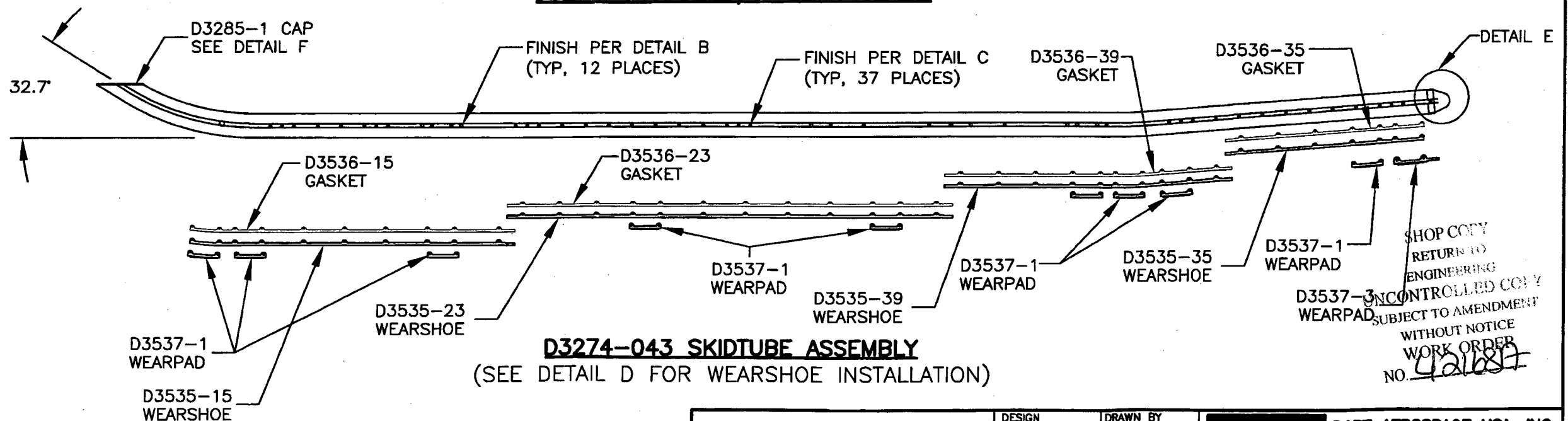
DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

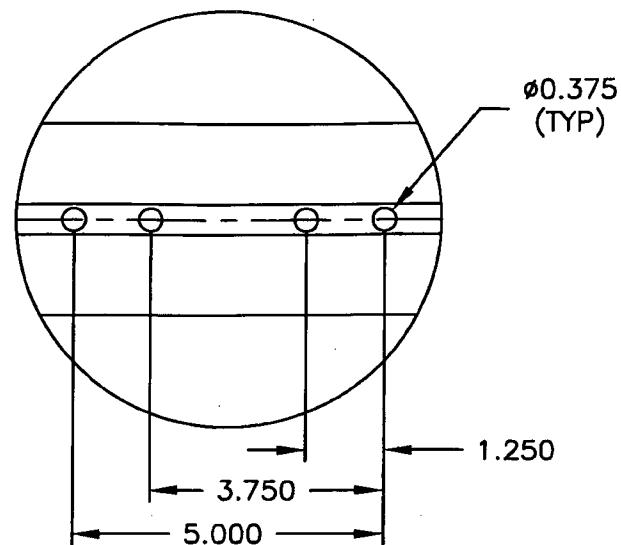
07.02.12

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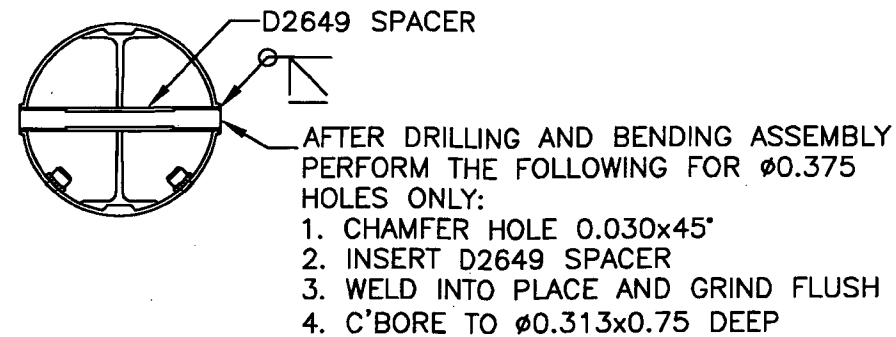
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DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 4 SCALE 1:15

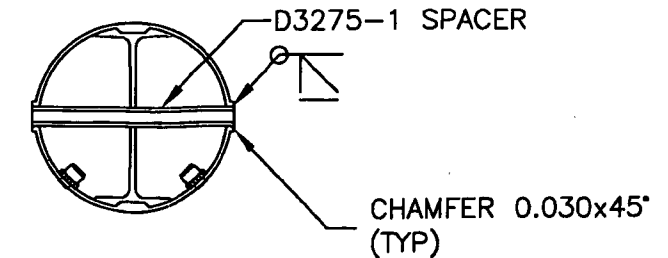
DETAIL A: DRILL DETAIL



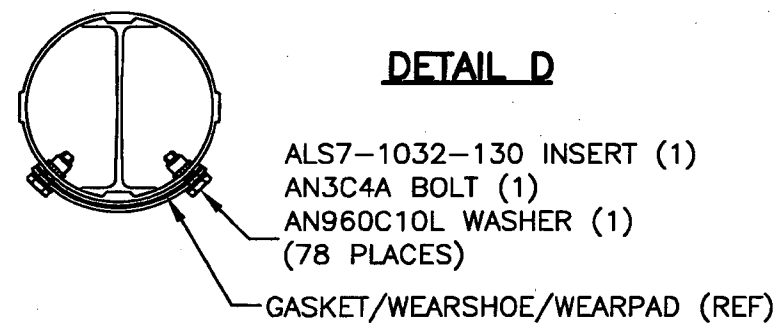
DETAIL B FOR $\phi 0.375$ HOLES ONLY



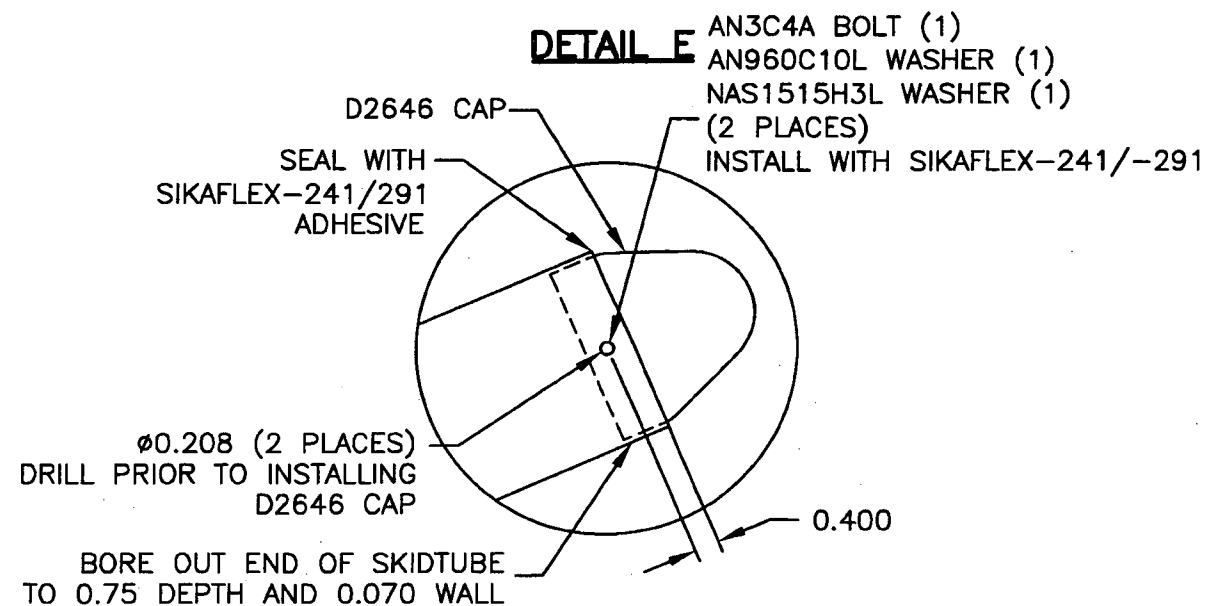
DETAIL C FOR $\phi 0.313$ HOLES ONLY



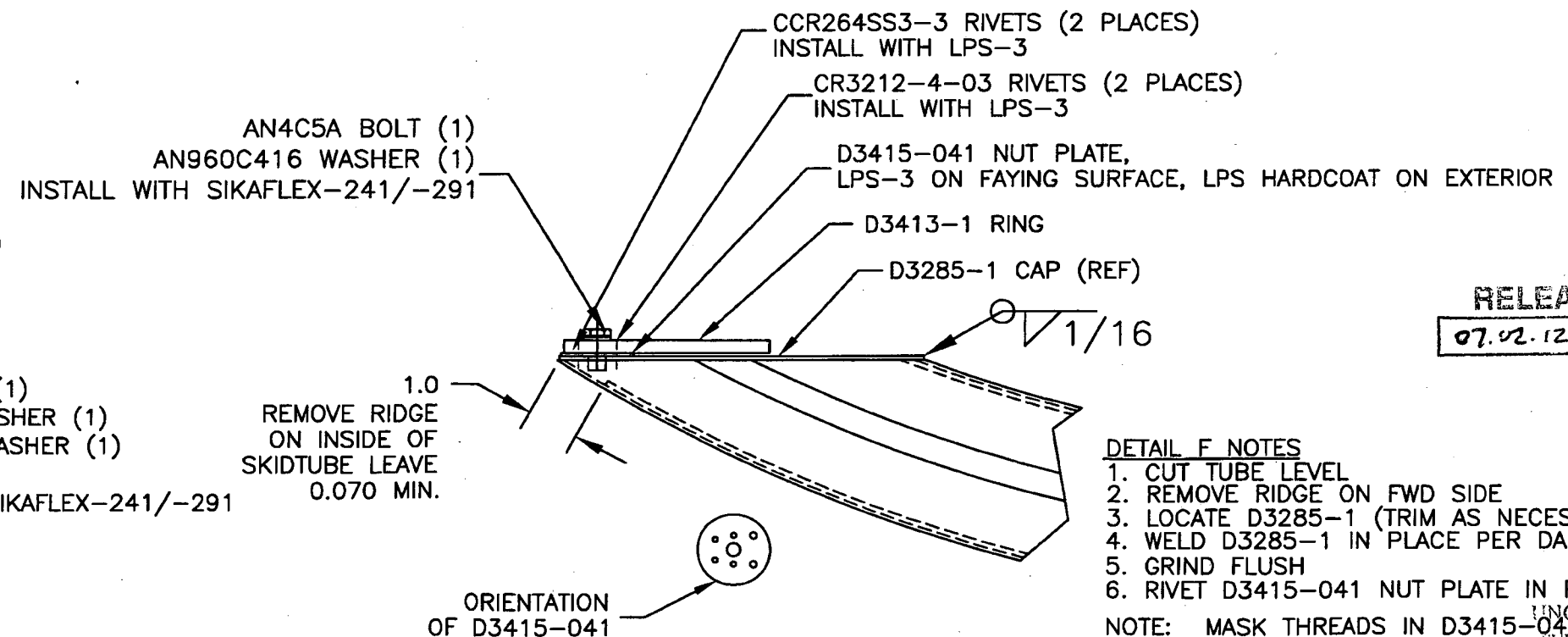
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

RELEASED
07.02.12

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CHECKED H	APPROVED H	DRAWING NO. D3274
DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY	REV. D SHEET 4 OF 4 SCALE 1:3

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WORK ORDER
NO. 421684

